

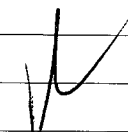
Work Order ID 131203

131203

Page 1

March-30-15 12:33:23 PM

Item ID: D117-1006-012 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: BK117 Bubble Window RH
 Start Date: 3/30/15 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 4/02/15 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D117-1006	B								MCS 150331
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPF-D117-1006-012 CHG 002								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
27
9-30

DAS
46
9-30

APR 10 2015

1x

DAS
27
9-30

MAR 31 2015

1x

DAS
46
9-30

APR 10 2015

1x

DAS
27
9-30

Work Order ID 131203

131203

Page 2

Item ID: D117-1006-012

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: BK117 Bubble Window RH

Start Date: 3/30/15 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 4/02/15 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D117-1006-012								
	Location: <u>106</u>								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

Handwritten: 106

Handwritten: APR 10 2015

Handwritten: 15-04-13

Handwritten: 15-4-13

Picklist Print

March-30-15 12:33:22 PM

Page 1

Work Order ID: 131203

131203

Parent Item: D117-1006-012

D117-1006-012

Parent Item Name: BK117 Bubble Window RH

Start Date: 3/30/15

Required Date: 4/02/15

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev. A New Issue 14/03/24 DL

IPP REV:B

14.06.25 AS PER IIN REV.B DD VERF:JLM

IPP REV:C 14.12.18

AS PER chg003 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3802-1-180		Manufactured	No			110	Each	0.0000	1	1			
D3802-1-180		DAS											
Window Seal - 180"		46											
D3932-1		Manufactured	No			110	Each	20.0000	2	2			
D3932-1		DAS											
Snap Vent		46											
		9-89											
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST077A	20							
					55837	14							
					88149	6							
D5034-2		Manufactured	No			110	Each	0.0000	1	1			
D5034-2		DAS											
Bubble Window		46											
D5093-041		Manufactured	No			110	Each	4.0000	1	1			
D5093-041		DAS											
Door Bracket Assembly		46											
		9-89											
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					prelim	1							
					116403	1							
					ST147	3							
					121331	3							

DAS
27

MAR 31 2015

DAS
27

MAR 31 2015

DAS
27

MAR 31 2015

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27

MAR 31 2015

Picklist Print

March-30-15 12:33:22 PM

Page 2

Work Order ID: 131203

131203

Parent Item: D117-1006-012

D117-1006-012

Parent Item Name: BK117 Bubble Window RH

Start Date: 3/30/15

Required Date: 4/02/15

Start Qty: 1.00

Required Qty: 1.00

D5094-041

Manufactured No

110

Each

5.0000

1

1

D5094-041

DAS
46
9-89

Post Bracket Assembly

**

DAS
27
9-89

MAR 31 2015

Location

Loc Qty

Loc Code

prelim

2

116404

1

123602

1

ST147

3

121330

3

B131203

D5107-1

Manufactured No

110

Each

10.0000

1

1

D5107-1

DAS
46
9-89

Placard

**

DAS
27
9-89

MAR 31 2015

Location

Loc Qty

Loc Code

ST148

10

121826

10

110

Each

10.0000

1

1

D5115-1

Manufactured No

D5115-1

DAS
46
9-89

Door Prop

**

DAS
27
9-89

MAR 31 2015

Location

Loc Qty

Loc Code

ST366

10

121302

10

110

Each

249.0000

45

45

AN3-7A

Purchased No

AN3-7A

DAS
46
9-89

Bolt

**

DAS
27
9-89

MAR 31 2015

Location

Loc Qty

Loc Code

ST338a

200

31420

200

ST349

49

M122913

5

M124901

5

M129706

39

24

21

2

24

30

24

March-30-15 12:33:22 PM

Shop Packet Print

Page 2

Picklist Print

March-30-15 12:33:22 PM

Page 3

Work Order ID: 131203

Parent Item: D117-1006-012

Parent Item Name: BK117 Bubble Window RH

131203

D117-1006-012

Start Date: 3/30/15

Required Date: 4/02/15

Start Qty: 1.00

Required Qty: 1.00

LN9139-0412

DAS
Purchased

No

110

Each

0.0000

2

2

I N9139-0412

46
9-89

Screw

LN9355-6X40

Purchased

No

110

Each

46.0000

2

2

I N9355-6X40

DAS
46

BOLT

Location

Loc Qty

Loc Code

ST554

46

m129319

46

110

Each

2,302.000

90

90

NAS1149D0363J

Purchased

No

NAS1149D0363J

DAS
46

Washer

Location

Loc Qty

Loc Code

CA

569

m130799

569

FP001

2

113288

2

GA

312

m128429

312

ST269

1419

m126319

9

m131618

1410

DAS
27

MAR 31 2015

DAS

MAR 27 2015

DAS
27

MAR 31 2015

Picklist Print

March-30-15 12:33:23 PM

Page 4

Work Order ID: 131203

131203

Parent Item: D117-1006-012

D117-1006-012

Parent Item Name: BK117 Bubble Window RH

Start Date: 3/30/15

Required Date: 4/02/15

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

2,075.000

45

45

MS21042L3

DAS
46

Nut

DAS
27
9-89

MAR 31 2015

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

420

M130922

420

GA

798

M131317

798

ST305

857

116549

12

126333

114

M128754

2

M131624

729

45

APR 10 2015

4.0 WEIGHT AND BALANCE

The following is the weight of the D117-1006-012 Bubble Window kit. It is the responsibility of the installer to account for the weight and balance of all removed parts.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D117-1006-012 Bubble Window Kit	6.89 lb 2.1 kg	44.8 in 1.1 m	308 in-lb 2.3 m-kg	112.9 in 2.9 m	778 in-lb 6.1 m-kg

5.0 PARTS LIST

Qty -012	Part Number	Description
X	D117-1006-012	BUBBLE WINDOW KIT
1	D3802-1-180	SEAL
2	D3932-1	SNAP VENT
1	D5034-2	BUBBLE WINDOW
1	D5093-041	DOOR BRACKET ASSY
1	D5094-041	POST BRACKET ASSY
1	D5107-1	PLACARD
1	D5115-1	DOOR PROP
45	AN3-7A	BOLT
2	LN9139-0412	SCREW
2	LN9355 6X40	BOLT
90	NAS1149D0363J	WASHER (AN960JD10)
45	MS21042L3	NUT